

633.011

Date: Wednesday, 03/06/2009 10:48:22 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 48348A	
Estimate Number : 10176	
P.O. Number :	Part Number : D2563
This Issue : 03/06/2009 S.O. No. :	Drawing Number : D2563 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 47834A	Material :
Written By :	Due Date : 30/06/2009 Qty: 4 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev:G 02.07.31 Re-format Location RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 338023

09.06.15 4

2.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch:

335887 = 7

336406 = 1

09.06.18 4

3.0	D2561	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch:

345177

09.06.18 4

4.0	D2564	Mounting Angle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch:

345243

09.06.18 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:22 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 48348A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

A/R AL ROD Batch: M110130
M110972

4- Grind

Handwritten signatures and dates:
09.06.18 4
09.06.18 4
09.06.18
09.06.19 4

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten signature and date:
09.06.19 4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature and date:
09.06.19 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten signature and date:
09.06.19

Handwritten circled number:
(4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten signature and date:
09.06.22 4

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M110130

3-Grind

Handwritten signatures and dates:
09.06.22 4
09.06.22 4
09.06.22 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:22 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 48348A

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09-06-22

4

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50206/22 (X4)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING pressure was 11 09-06-22 X4
Touch up Alodine then H. 09-06-22 X4
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:00 AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 8:30 AM

JP

09-06-23 (X4)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

M111013

A.M. 09-03-23 (X4)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PPN 48348 9/6/24

809/06/23 (X4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



U 09.06.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

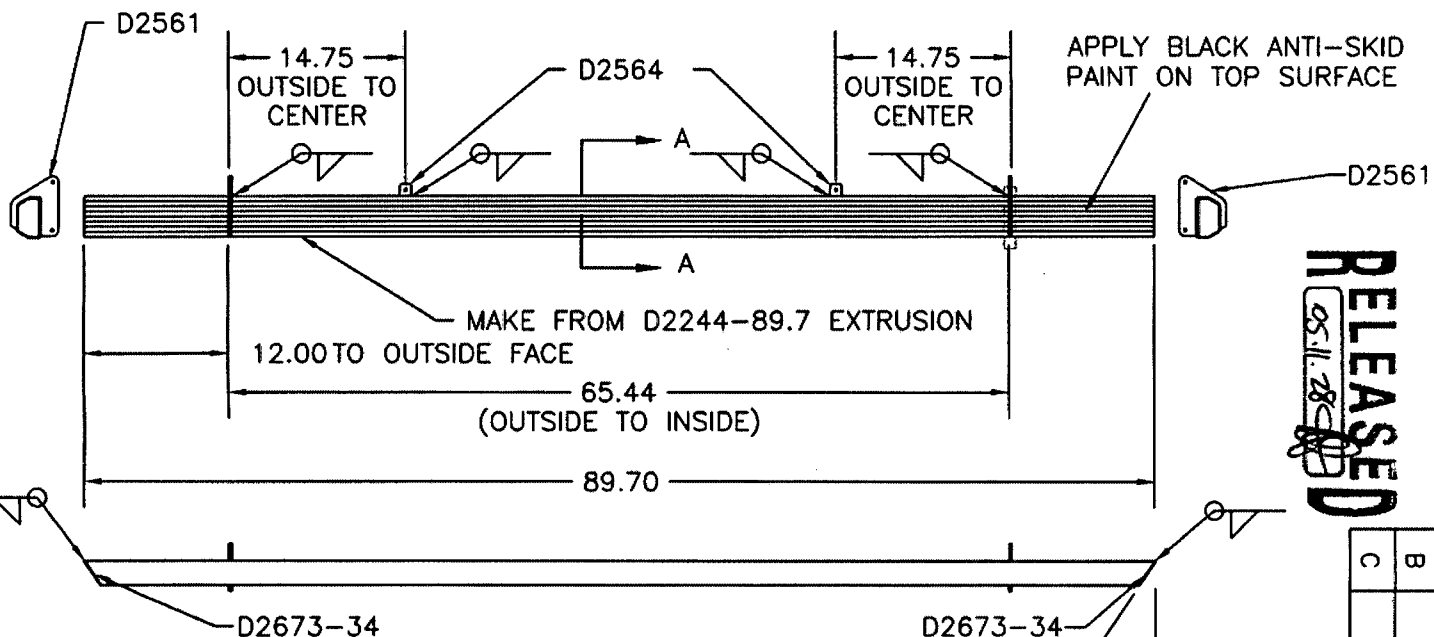
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

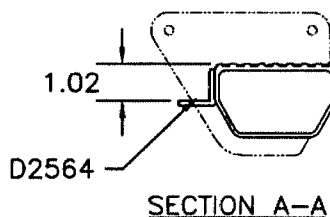
RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 10338

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.11.14	05.11.14	D2563
DATE	TITLE	REV. C
05.11.14	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES
		SCALE 1:15